visually stimulating

RFP COLLECTION
WILSONART SYNERGY SERIES
TAFISA DESIGN COLLECTION
The most common way to fabricate Roseburg Melamine panels is by mass-produced parts with intricate detail being laboriously cut from tooling. Tungsten carbide tools are often used when runs of mass-produced parts with intricate detail are being fabricated. They tend to have a longer life cycle between sharpening, allow for faster speeds, maintain original contour, and can provide a smoother finish than carbide tools. (Caution: Diamond tools can be more delicate than carbide. The tool manufacturer should be consulted to ensure the best product is used to meet fabricating specifications.)

The most important piece of machinery required to fabricate melamine is a high-quality panel saw with a scoring blade. All sawing machines must be checked often to be certain they are in alignment. The ways must be straight and true, the carriage tight, and each saw perfectly aligned with each other. This through blade needs to run straight and not have bearings, tightness in good condition, and the work hold-downs applying proper pressure on the melamine. The sawblades must be ground accurately and truly.

Roseburg recommends consulting both your tooling and machine manufacturers, to ensure proper tooling and machine specifications. Carbide-tipped router bits and shaper cutterheads are the best products available for Roseburg Melamine. Because cutting details for the wide range of finished products can vary greatly, it’s impossible to make recommendations for every application. It is recommended that you work closely with the tooling supplier to select the right tool for your application.

Roseburg Melamine can be edged with a variety of treatments such as polyvinyl chloride (PVC), polyester, solid wood or veneer, soft formed melamine, or high pressure laminates. Plastic and metal molding can also be used as edging materials.

PREPARATORY WORK

Prior to fabrication Roseburg Melamine panels should be stored flat on a sufficient number of evenly spaced slotted or wooden supports, and allowed to acclimate for 48-72 hours. Optimum storage conditions are temperatures between 60 degrees and 90 degrees F (15-30 degrees C) with a relative humidity of 45-65%.

Roseburg Melamine may be affected by severe climatic changes that cause the relative humidity to vary and can result in warping, swelling, or shrinking. Unbanding the units and allowing the panels to acclimate inside the shop for a minimum of 72 hours before fabricating will minimize the effect.

Panels should always be stored horizontally to prevent warpage and edge damage. Proper support is important to maintain flatness. Avoid unnecessary flexing of the panels when lifting by transport machinery.

STORAGE & HANDLING

Prior to fabrication, Roseburg Melamine panels should be acclimated inside the shop for a minimum of 72 hours before fabricating will minimize the effect.

MACHINING

Roseburg Melamine can be machined as effectively as solid woods. Proper machining techniques are applied. Roseburg recommends consulting both your tooling and machine manufacturers, to ensure proper equipment is used to fabricate Roseburg Melamine.

Other key factors, such as tool design, speed, material feed rate, and quality of cutting equipment are important to successfully fabricate melamine. A good tool maintenance program is critical to controlling the quality and consistency of the cut.

TOOLING

Carbide or diamond-tipped cutting tools are recommended for fabricating RMP Melamine. Carbide-tipped. The most common way to machine melamine is with a carbide tipped tool, employing tungsten carbide and modified grades of tungsten carbide in its makeup. It is recommended that you work closely with the supplier to ensure the grade of carbide is hard enough to provide a good consistent cut.

Diamond-tipped. Diamond tipped cutting tools can also be used to fabricate melamine. Diamond tools can be up to 15% faster when compared to carbide. They are often used when runs of mass-produced parts with intricate detail are being fabricated. They tend to have a longer life cycle between sharpening, allow for faster speeds, maintain original contour, and can provide a smoother finish than carbide tools.

SAWING

The sawblade design and high quality equipment are the basic requirements needed to achieve successful fabrication. There are three angles from which the sawblade should cut melamine: clearance angle, hook angle, and approach angle.

JOINING & FASTENING

Panels may be joined with the most common woodworking joints. These include dovetails, wedges, collar lugs, and screw fastening systems especially designed for melamine.

EDGE TREATMENTS

Roseburg Melamine can be edged with a variety of treatments such as polyvinyl chloride (PVC), polyester, solid wood or veneer, soft formed melamine, or high pressure laminates. Plastic and metal molding can also be used as edging materials.

MAINTENANCE & REPAIRING

Panels can be easily cleaned with soapy water and mild soaps. Do not use cleansers containing abrasives, acids, or oils. Over-spray adhesives are easily removed with solvents recommended for such use.

Fabricated melamine panels can be repaired in the same manner as a high-pressure laminate. Plastic seam fillers can be purchased to match the proper color and are easy to apply. Contact your local Roseburg Melamine distributor as a source for this product.

FABRICATION STANDARDS

Cabinets constructed with thermo-fused melamine will conform to relevant sections of standards set by the Kitchen Cabinet Manufacturers Association (KCMA), ANSI A156.1-1995, Woodworking Institute(WI). Standards for exposed and semi-exposed surfaces of cabinet bodies.

RECOMMENDED SAWBLADE SPEEDS:

<table>
<thead>
<tr>
<th>Size</th>
<th>Speed (RPM)</th>
</tr>
</thead>
<tbody>
<tr>
<td>8&quot;</td>
<td>3,600</td>
</tr>
<tr>
<td>10&quot;</td>
<td>3,600</td>
</tr>
<tr>
<td>12&quot;</td>
<td>3,600</td>
</tr>
<tr>
<td>14&quot;</td>
<td>3,800</td>
</tr>
<tr>
<td>16&quot;</td>
<td>3,800</td>
</tr>
</tbody>
</table>
THE BOARD MATTERS
Roseburg Forest Products has the distinct advantage of manufacturing our own highly acclaimed "UltraBlend™" and Missoula Pine particleboard specifically engineered for our Roseburg Melamine decorative panels. This vertical integration allows for complete quality control from start to finish.

- UltraBlend™ - a proven and trusted blend of Western softwoods, providing the strength and stability of fir, with the machinability of pine in an industrial particleboard panel.
- Missoula Pine - a high quality industrial particleboard panel with ultimate machinability.
- Medium Density Fiberboard (MDF) - Roseburg Melamine is also available on many of the West’s highest quality MDF cores.

REDFLY
Seven hardwood veneers (unfinished or pre-finished) laminated one side, and #11 White, #16 Almond or #55 Hard Rock Maple Roseburg Melamine on the reverse side.

ENVIRONMENTAL AWARENESS
Roseburg has Scientific Certification Systems (SCS), a neutral third party environmental testing and certification organization, audit our manufacturing process that verifies our UltraBlend™ and Missoula Pine particleboard is produced from recycled/recovered wood fiber.

TECHNICAL SPECIFICATIONS
PARTICLEBOARD & MDF SUBSTRATE

<table>
<thead>
<tr>
<th>Property</th>
<th>Roseburg UltraBlend™ Particleboard</th>
<th>Roseburg S Melamine Particleboard</th>
<th>Medium Density Fiberboard (MDF)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Moisture Content</td>
<td>7%</td>
<td>7%</td>
<td>4-7%</td>
</tr>
<tr>
<td>Density</td>
<td>45 lbs</td>
<td>45 lbs</td>
<td>—</td>
</tr>
<tr>
<td>Modulus of Rupture (MOR)</td>
<td>2100 psi</td>
<td>2100 psi</td>
<td>3600 psi</td>
</tr>
<tr>
<td>Modulus of Elasticity (MOE)</td>
<td>350,000 psi</td>
<td>350,000 psi</td>
<td>350,000 psi</td>
</tr>
<tr>
<td>Internal Bond</td>
<td>90 psi</td>
<td>90 psi</td>
<td>90 psi</td>
</tr>
<tr>
<td>Hardness</td>
<td>750 lbs</td>
<td>750 lbs</td>
<td>—</td>
</tr>
<tr>
<td>Screwholding - Face</td>
<td>250 lbs</td>
<td>250 lbs</td>
<td>325 lbs</td>
</tr>
<tr>
<td>Screwholding - Edge</td>
<td>190 lbs</td>
<td>250 lbs</td>
<td>250 lbs</td>
</tr>
<tr>
<td>HCHO Maximum</td>
<td>0.50 ppm</td>
<td>0.30 ppm</td>
<td>0.30 ppm</td>
</tr>
</tbody>
</table>

2. Typical test results conducted on actual Roseburg particleboard using procedures outlined in AEM D-307-64

MELAMINE MINI-PAK PROGRAM
A special selection of Melamine woodgrains and abstract patterns can be ordered from Roseburg in convenient mini-units. Roseburg’s Melamine Mini-Pak program is perfect for those projects that require small quantities of our special melamine products.

- CONVENIENT PACKAGING - 10 piece units, individually strapped for easy handling
- POPULAR THICKNESS/SIZES - 1/4" MDF (finished 1 side) and 3/4" Missoula Pine (finished 2 sides) in 49”x97” panels
- WIDE SELECTION - 14 Popular Roseburg Melamine designs
- AVAILABILITY - Timely shipment from stock or with your regular order within our normal lead time

Look for the “x” next to samples for Mini-Pak availability.
**GENERAL INFORMATION**

Roseburg Melamine decorative panels consist of melamine resin saturated decorative papers, thermally fused under heat and pressure to a substrate of Roseburg UltraBlend particleboard, Missoula Pine particleboard, or MDF (medium density fiberboard). The Thermally Fused Melamine (TFM) process permanently bonds the paper and the board; there is NO GLUE LINE to delaminate. The panels resist warping, bowing, scratches, stains, heat, steam, burning, abrasion, chip-out and damage due to excessive wear. Roseburg Melamine Decorative Panels perform like high pressure laminate at a fraction of the cost.

**PANEL FACE**

Hundreds of solid, pattern and woodgrain designs are available from Wilsonart, Tafisa and other sources that perfectly match high pressure laminates and rigid thermo foils.

**PANEL BACKS**

Panels are available with decorative faces two sides or with a white or brown melamine saturated balancing backer sheet. A glueable backer is available for panels which will subsequently be laminated with high pressure laminates or other materials.

**PANEL FINISH**

Roseburg melamine panels are available with either "Z" – Satin finish, for a textured furniture grade appearance, or "S"- Matte finish for a low gloss textured appearance.

**APPLICATIONS**

**RESIDENTIAL**
- Kitchen and bath cabinets
- Ready-to-assemble furniture
- Entertainment centers

**COMMERCIAL**
- Store fixtures and displays
- Office furniture and partitions
- Computer furniture

**INSTITUTIONAL**
- Hotel and motel furniture
- Restaurant furniture
- Hospital and medical casegoods
- Institutional interiors

**HOW TO SPECIFY**

Product: Roseburg Thermally Fused Melamine Panels

Color name: ____________________________ Color Ref. #: __________________

Finish: "S" - Matte or "Z" - Satin

Substrate type: UltraBlend, Missoula Pine particleboard or Medium Density Fiberboard (MDF)

Width: _________________ Length: _________________ Thickness: _________________

**CUSTOMER & TECHNICAL SERVICES**

Roseburg Forest Products' skilled and knowledgeable sales team is highly trained to work with each customer to meet their specific product and service requirements. Located at our largest manufacturing complex in Dillard, Oregon, they provide sales assistance, product information, order processing, scheduling and transportation services. In addition, Territory Sales Managers (TSMs) are strategically located to serve customers throughout the United States and Canada. These trained professionals provide sales assistance, product and technical support. The TSMs work closely with their customer's sales, purchasing, manufacturing and engineering personnel to assure that Roseburg satisfies their needs.
PRODUCT PERFORMANCE

Roseburg Melamine panels are highly resistant to: scratching, stains, abrasion, edge chip-out, burnishing, steam, radiant heat, impacts, scuffs, moisture, and light.

SURFACE PROPERTIES

<table>
<thead>
<tr>
<th>TESTS FOR REFERENCE TO</th>
<th>TEST DESCRIPTION^</th>
<th>ROSEBURG MELAMINE</th>
<th>NEMA LD3 2000-VGL MINIMUM PERFORMANCE STANDARD</th>
</tr>
</thead>
<tbody>
<tr>
<td>WEAR</td>
<td>A measure of the ability of a decorative overlaid surface to maintain its design or color when subjected to prolonged abrasive wear</td>
<td>400 cycles</td>
<td>400 cycles</td>
</tr>
<tr>
<td>SCUFF</td>
<td>A measure of the ability of a decorative overlaid surface to maintain its original appearance when subjected to prolonged scraping or scuffing</td>
<td>No effect</td>
<td>No effect</td>
</tr>
<tr>
<td>STAIN</td>
<td>A measure of the ability of a decorative overlaid surface to resist any discoloration or marring by prolonged contact with 15 common household agents</td>
<td>No effect - 1-11, 15 Moderate - 12-14</td>
<td>No effect - 1-10 Moderate - 11-15</td>
</tr>
<tr>
<td>CLEANABILITY</td>
<td>A measure of the ability of a decorative overlaid surface to be cleaned following prolonged contact with 15 soiling agents, using a sponge-scrubbing device</td>
<td>No effect. Surface cleaned in 10 or fewer strokes.</td>
<td>Surface cleaned in 20 or fewer strokes.</td>
</tr>
<tr>
<td>LIGHT</td>
<td>A measure of the ability of a decorative overlaid surface to retain its color after prolonged exposure to a light source having a frequency range approximating sunlight</td>
<td>Slight</td>
<td>Slight</td>
</tr>
<tr>
<td>HIGH TEMPERATURE</td>
<td>A measure of the ability of a decorative overlaid surface to maintain its color and surface texture when a hot pot of 180˚C (356˚F) is placed on it for 20 minutes</td>
<td>Slight</td>
<td>Slight</td>
</tr>
<tr>
<td>RADIANT HEAT</td>
<td>A measure of the ability of a decorative overlaid surface to resist any damage when subjected to a radiant heat source under controlled laboratory conditions</td>
<td>No effect after 60 seconds</td>
<td>No effect after 60 seconds</td>
</tr>
<tr>
<td>BOLLING WATER*</td>
<td>A measure of the ability of a decorative overlaid surface to maintain its color and surface texture when subjected to boiling water for a period of 30 minutes</td>
<td>No effect</td>
<td>No effect</td>
</tr>
<tr>
<td>IMPACT</td>
<td>A measure of the ability of a decorative overlaid surface to resist fracture due to the impact of a 1/2 pound steel ball dropped from a measured height</td>
<td>15” without fracture</td>
<td>15” without fracture</td>
</tr>
</tbody>
</table>

COLORS AND PATTERNS: Roseburg Melamine is recommended for all horizontal and vertical applications, with the exception of surfaces where heavy use is anticipated or which will be exposed to temperatures exceeding 270˚ F (135˚ C). Roseburg Melamine panels are designed for interior or protected area use only.

PERFORMANCE STANDARDS

Roseburg’s thermally fused melamine panel typically meets or exceeds performance standards set by:

- Woodwork Institute (WI) for premium, custom, or economy cabinets for exposed or semi-exposed surfaces.

Colors and patterns shown are printed reproductions and may differ slightly from the actual product.

Key:
- Mini-Pak item
- Designed to Match item
- Minimum 1 unit order, per design. Exceed Mini-Pak items.